

Flush-mount ship 12/06

Dart Aerospace Ltd.

split 8B 07/09/11

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32909
Estimate Number : 12336
P.O. Number : *N/A*
This Issue : 14/06/2007 S.O. No. : *N/A*
Print Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 32909
Written By :
Checked & Approved By :
Comment : Est: C 99.08.23 Returned to Electro Polish DM
Est Rev:D Now on WaterJet 07-06-14 JLM

Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT LH
Part Number : D206555007
Drawing Number : D206-555 REV C
Project Number : N/A
Drawing Revision : C
Material : *N/A*
Due Date : 22/06/2007 Qty: 10 Um: Each

Additional Product

Job Number:



Seq #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-007

2.0

M304S25GA

304/316 .020" Sheet



Comment: Qty.: 0.4410 sf(s)/Unit Total: 4.4100 sf(s)

304/316 .020" Sheet

Batch: *4102 504*

3.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7

Finish form on bench forming Jig DT8321-7

Remove tooling tabs and deburr

Thursday, 14/06/2007 10:30:20 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 32909

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description:

80

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 2/10/11 (13)

7C

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O:

Possible supplier: TQF Technologies

Handwritten: PTO

8C

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Handwritten: n/a

90

QC5

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: En 2/10/11

Handwritten: (x1)

10C

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Handwritten: 2/8/11

Handwritten: SD

Handwritten: (1x)

110

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 2/10/11 (1)

Handwritten: 2/10/11

Job Completion



000

Dart Aerospace Ltd

WORK ORDER CHANGES

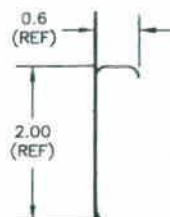
W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						
17-06-18	7.0	Hand Polish using a buffer; Walter's blue & white metal Polish. Blue #WAL 07T90S M <u>104786</u> AIR White WAL 07T90W M <u>104789</u> AIR Dwg to be updated.	SB	07/09/11	1	[Signature] 07.06.19	2 07-06-18
07/09/11	7	split w/o	SB	07/09/11	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

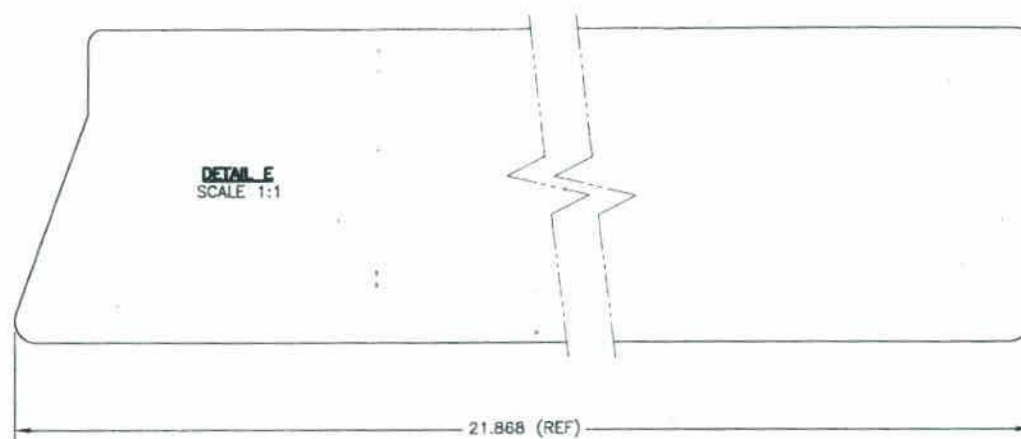
WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION F-F
DETAIL OF
BENDING SHOWN



DETAIL E
SCALE 1:1

REFER TO DETAIL E
FOR 1:1 SCALE



FLAT PATTERN

RELEASED

06.09.19

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) ~~FINISH: ELECTROCHEMICALLY POLISH PER ASTM B812 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES~~ 306 W/O CHANGES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

STEP 7.0

DESIGN	JB	DRAWN BY	JB	DART	DART AEROSPACE LTD	REV. C
CHECKED	PH	APPROVED	PH	DRAWING NO.	D206-555	SHEET 5 OF 7
DATE	06.09.01	TITLE	DOOR SILL SCUFF PLATES	SCALE	2:3	